

Date: Wednesday, 18/06/2008 1:27:54 PM
User: Julie Lecocq

Split WO
SB 08/07/17

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	FLANGE ASS'Y		
Job Number	39935			Part Number	D3651043		
Estimate Number	13032			Drawing Number	D3651 REV.B		
P.O. Number	:			Project Number	N/A		
This Issue	18/06/2008	S.O. No.	:	Drawing Revision	B		
Prsh Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	07/07/2008	Qty:	2 Um: Each
Previous Run	37142						
Written By	:						
Checked & Approved By	JUD 08-06-18						
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
	Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s) 304/316 SS sheet 26 ga (0.018" thick)	
	Batch: 108415 HB 8-6-26	
	(FOR D3651-7)	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	
	1-Cut as per Dwg D3651 (D3651-7)	
	Dwg Rev: B	
	Prog Rev: B	
	HB 8-6-26	(3)
	2-Deburr if necessary	
	IDENTIFY AS D3651-7	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	HB 8-6-26	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	JUN 06-27	(3)
	Comment: SECOND CHECK	



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Job Number: 39935

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	M304S26GA	304/316 0.018 SHEET
Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>108415</u> <u>B 8-7-2</u>		
(FOR D3651-5)		
6.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3651 (D3651-5) Dwg Rev: <u>B</u> <u>B 8-7-2</u> Prog Rev: <u>B</u> <u>(3)</u>		
2-Deburr if necessary Identify as D3651-5 <u>B 8-7-2</u>		
7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>B 8-7-2</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
8.0	QC8	SECOND CHECK
<u>(S) 08/07/02 (x3)</u>		
Comment: SECOND CHECK		
9.0	BRAKE NC	NC BRAKE
<u>(S) 08/07/02 (x3)</u>		
Comment: NC BRAKE		
Form D3651-5 and D3651-7 as per Dwg D3651		
10.0	QC5	INSPECT WORK TO CURRENT STEP
<u>(S) 08/07/02 (x3)</u>		
Comment: INSPECT WORK TO CURRENT STEP		
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld assembly as per dwg D3651		
<u>(P) 08/07/10 (3)</u>		



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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08/07/14 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/14 (3)

14.0

D36513

Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BASE B 40193

FF 08-07-21

15.0

MS20427M33

Rivet

FF 08-07-21



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

M 106993 ~~106993~~ \$

FF 08-07-21

16.0

MS210603K

Nut Plate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

M 105938

FF 08-07-21

17.0

CR3523401

RIVET



Comment: Qty.: 57.0000 Each(s)/Unit Total : 114.0000 Each(s)

RIVET

M 106 375

FF 08-07-21

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3651

FF 08-07-21

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/21 (4)



Process Sheet

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

S8 08/07/21 ①

21.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/30/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-29



DART AEROSPACE LTD	Work Order:	39935
Description: Bottom Flange	Part Number:	D3651-7
Inspection Dwg: D3651	Rev: B	Page 1 of 1

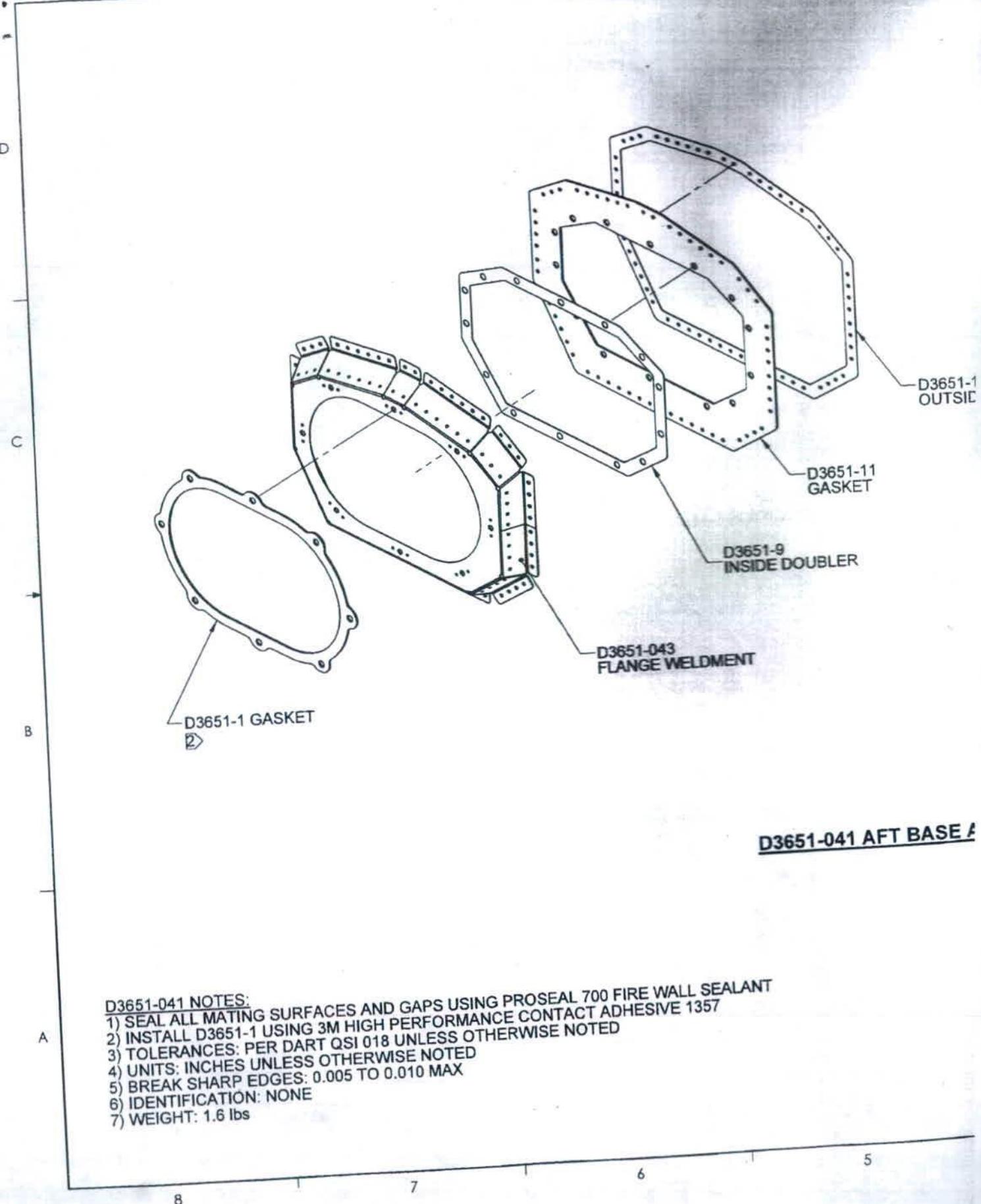
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

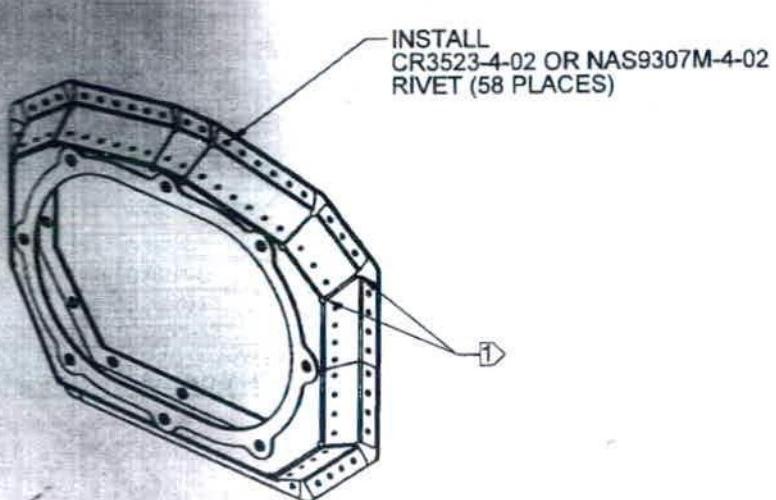
Measured by:	<u>kg</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>8-6-24</u>	Date:	<u>08/06/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	P/O D3651-043	KJ/DD  









DUBLER

D

C

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASER
08-03-27 MWD
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 319132

MBLY

A

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504			RF	08.01.07
A	NEW ISSUE			RF	07.11.07
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	LE	DRAWING NO. D3651			REV. B
MFG. APPR.	DA	SHEET 1 OF 9			
APPROVED	TA	TITLE AFT BASE ASSEMBLY			SCALE 1:4
DE APPR.	TA				
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

